116579

Page 1

Thursday, April	17, 2014	3:17:42 PM			1:179"			•			. Tage 1
Item ID: Revision ID: Item Name:	D3609-1 Doubler			Accept	*N900	040	100	0 *	_	art * \	IS1* IS2*
Start Date: Required Date: Reference:	4/21/14 4/22/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					J. 7/
Approvals:	Process	Plan:	Date: 4'04-17	- Tooling:	Da	ate:	_]			JR1*
	QC:		Date:	SPC (Y/N):	D:	ate:			S	top * /	IR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Insp.
Draw Nbr	, " I	Revision Nbr		•							
D3609	Ι)	•								
100				0.00				~			ψ.ü
100		FLOW WATER JET						(6) 9	!-(n	m/a	14/04/21
Waterjet FLOW CNC Waterj	et	Dwg Rev:_ Prog Rev:_	RATCH ON TOP SURF	0.00 FACE***							
110		QC2- Inspect parts off i	nachine FAI/FAIB	0.00							
110								(X) 9	-6	n - 1a	امل حامنا
QC		Memo		0.00					- 2	mm /el	14/04/21
Quality Control									D7	5	

Work Order:	DQA:	W/	Date:	14/65/	01					,			TQ &C
Disposition	/ /	121		(/	1 12	WORK ORDER NON	I-CC	ONFO	RMANCE / UF			–	AEROSPACE
Rework Skid-tube Skid-tube Machining Frod. Eng. Coor. Engineering Quality Other	QA Closed: (19H	Date:	14/	410					We	ork Order up	date only	
Part No. 1369-1 Rework Scrapk Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor Quality Other Root Cause Date Step Qty Description of work order update Order Composite	Work Order	11105	79		·	DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No. 13609-1 NCR No. 14-3785 Suspected Unapproved Suspected Unapproved Large Fab Composite Composite Suspected Unapproved Large Fab Composite Composite Suspected Unapproved Large Fab Composite Composite Composite Suspected Unapproved Composite Compos	Work Order.	110	<u> </u>			Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering
NCR No. + - 3785 Suspected Unapproved Thermoforming Large Fab Composite Supplier Other Othe	Part No.	D36	09-	\		<u></u>		1	—	 	Pro	d. Eng. Coor.	4 · 1—4
Root Cause Date Step Qty Or non-conformance Description Date Description Date Verification QC Inspector Design Doc/Data Doc/Da					_	· —	1	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Pre Handling/Pre Material Operator Operator Operator Operator Unapproved Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Unspection Strip in Tube Marks/Chatter Turning Sequence Contamination Cut for Chief Eng Description Date Verification QC Inspector ACL P and Data ACL P and Data ACL P and Data ACL P and Data Data ACL P and Data ACL P and Data Driss Driss Driss Driss Driss Driss Data ACL P and Data Driss Driss Driss Driss Data ACL P and Data Driss Driss Driss Data ACL P and Data Driss Driss Driss Driss Driss Data ACL P and Data Driss Dri	NCR No.	<u> 14 - :</u>	5/6	<u> </u>		Suspected Unapproved]		Large Fab	Composite		Supplier	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Pre Handling/Pre Material Operator Operator Operator Unapproved Unapproved Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Unspection Strip in Tube Unspection Step In Tube Unspection Strip in Tube Unspection Step In Tube Unspection Strip in Tube Unspection Strip in Tube Marks/Chatter Turning Sequence Containing Sequence Chief Eng Description Date Verification OCL Inspector Chief Eng Description Chief Eng Date Chief Eng	Poot			1	Desc	rintion of work order undate		nitial	Δct	ion	Sign &		
Design Doc/Orise Doc/Orise Equip/Tooling Haart Ireat Unapproved Design Doc/Orise Equip/Tooling How Material Dury study original To Not Dury study original		Date	Sten	Otv	Desci	•	1		ł .			Verification	OC Inspector
Doc/Data EquipTooling Handling/fre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Landing Gear General Bending Centre Not Concentric Cracks Cra		, .	Осер	~~,	1	1 11 1	+		'n	1 0 201	1		
tauip/Tooling MMM D	ı —	1 //			ω	o not updated	1/2	_	Mar c	rol between	*/	T .	•
Handling/Pre Material Operator Oprecess Supplier Training Transport Unapproved Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Custing Contamination Custing Contamination Contamination Contamination Contamination Contamination Countersink Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Operator Over/Under tolerance Part Lost/Missing Weld Wrong Stock Pulled Positioned Wrong Positioned Wrong Power Loss/Surge Pother Out Too Short Missaligned/off center Missabeled Marks/Chatter Drill Holes Off-set Out of Calibration	Equip/Tooling	141412	160	-6X	,	+- , \	1	1:44.29		Ø	JM	\$\forall 9 \land 1 \forall 2 \forall 9	
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Fault Category Faul	Offset/Setup	1			16	regular SS.			mzal	SARCAYP			
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Transport Unapproved Control Co	!	-			CC	d not polehad			B# 1265	1FZ			
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Landing Gear General	<u>-</u>	1			\mathcal{T}	LNts ^V)			1 51 /	.30			
Bending Bend Folio/Program Outside Dimensions Pressure/Forced Set-up Cracks Broken/Damage/Defect Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Crushing Countersink Cut Too Short Mislabeled Inspection Strip in Tube Drawing Marks/Chatter Turning Sequence Finish Bend Folio/Program Outside Dimensions Pressure/Forced Set-up Cover/Under tolerance Set-up Temperature/Cure Part Incorrect Temperature/Cure Part Lost/Missing Weld Inspection Incomplete/Unclear Mislaligned/off center Positioned Wrong Power Loss/Surge Other Dusc Power Loss/S				•			FA	ULT CA	TEGORY	· · · · · · · · · · · · · · · · · · ·			
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Crimp/Kink/Ripple/Wave Cuffs Contamination Crushing Heat Treat Inspection Incomplete/Unqualified Cut Too Short Inspection Strip in Tube Marks/Chatter Turning Sequence Inspection Incomplete/Unqualified Inspection Incomplete/Unclear Inspection Incomplete/Unclear Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Misaligned/off center Mislabeled Misread Off-set Out of Calibration Part Lost/Missing Part Lost/Missing Pour Moved Positioned Wrong Power Loss/Surge Other Ducy To pour Met		Centre No	ot Concer	ntric		-i		Grain			┪		-
Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Ducy Misread Misread Turning Sequence Finish Out of Calibration		-				Broken/Damage/Defect		-1				<u> </u>	⊣ '
Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Dusc Inspection Strip in Tube Drawing Misread Not updated Turning Sequence Finish Out of Calibration		⊣	nk/Ripple	/Wave	ļ	4	<u> </u>	-l		· —		_	_
Heat Treat Inspection Strip in Tube Inspection Strip in Tube Misread Marks/Chatter Turning Sequence Cut Too Short Mislabeled Misread Misread Off-set Out of Calibration Mislabeled Power Loss/Surge Other Dug Four Coss/Surge Other Dug Out of Calibration		⊣			-	4	<u> </u>	-	•	Jnclear	-1		J Wrong Stock Pulled
Inspection Strip in Tube Misread Marks/Chatter Turning Sequence Drawing Misread Off-set Out of Calibration		⊣				∄	-	-	-	<u> </u>	-1	_	Jothan Di A
Marks/Chatter Drill Holes Off-set Turning Sequence Finish Out of Calibration	-	4		Tuba	ļ		-	-		L	⊿ \	7 1 1 -	1 1 1 1 1 1 1
Turning Sequence Finish Out of Calibration		-1		rube	-	-	\vdash	4			The time	where I	a perside
	-				-		-	-			1,10	<i>∞</i> · 1	
		⊣ ັ	•			Fit/Function		-1					

Work Orde Thursday, April				*11	6579*							Page 2
Item ID: Revision ID: Item Name:	D3609-1 Doubler		1, 10	Accept	*N9000	140	100)*	Setup	Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	4/21/14 4/22/14	Start Qty: 6.00 Req'd Qty: 6.00		ጉ* ጉ*	Cust Item ID Customer:	:					, id.	
Approvals:	Process P QC:	lan:	_ Date:	Tooling: SPC (Y/N):	Date]	Run	Start Stop		R1* R <i>2</i> *
Sequence ID/ Work Center II 120 *1 20* QC Quality Control)	Operation Description QC8- Inspect parts - sec	ond check	Set Up/ Run Hours 0.00	Tool ID SDAS 27 9-49	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
121 *191* Brake NC Brake NC		Form as per dwg Memo USE DT976	50 TOOL	0.00			9	12)				PF 14-04-2
122 *199* Small Fab		Memo		0.00			9	18)			FF 14-04-2

1- TRIM AS PER DWG USING GUIDE LINES 2- BUFF SCRATCHS WITH LINE MATE (RED SCOTCH BRIGHT) TOP SURFACE ONLY

Small Fab

DQA:		Date:											TARGE
					WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only		
Work Order:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
					Rework	1		Skid-tube Crosstube	e		Water Jet		Engineering
Part No	٠.				Scrap	1 1		Machining Small Fal		Pro	d. Eng. Coor.		Quality
					Use-as-is	1	Therr	noforming Finishin	g	Rec/Sto	re/Packaging		Other
NCR No	·				Suspected Unapproved			Large Fab Composite	e		Supplier		
Root				Desc	ription of work order update		nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	_	QC Inspector
Design	_												
Doc/Data	_											,	
Equip/Tooling	4	ł				Ì					·		
Handling/Pre	4												
Material	4												
Operator	4												
Offset/Setup	-{	1											
Process	4												
Supplier	4	}											
Training	-					1							
Transport	\dashv												
Unapproved				<u> </u>		ΕΛΙ	III T CA	I TEGORY		1			
Landing	Gear		•		General	17	OLI CA	ILGORI					
	Bendir	σ			Bend]Folio/F	Program	Г	Outside Dim	ensions		Pressure/Forced
! ⊢	_	Not Conce	ntric		BOM/Route	\vdash	Grain	10814111	\vdash	Over/Under			Set-up
<u> </u>	Cracks		110110		Broken/Damage/Defect		Hardwa	are	-	Part Incorre			Temperature/Cure
		Kink/Ripple	e/Wave		Burrs	\vdash	4	ion Incomplete/Unqualified		Part Lost/Mi	1		Weld
! -	Cuffs		,	-	Contamination	\vdash	- '	tions Incomplete/Unclear		Part Moved		_	Wrong Stock Pulled
-	Crushi	ng			Countersink		4	gned/off center		Positioned V	•		
\ \	Heat T				Cut Too Short		Mislab			Power Loss/	_		Other
	-	tion Strip in	Tube		Drawing		Misrea		_	· ·	-		
ļ	_ `	/Chatter		-	Drill Holes		Off-set						· ·
	_	g Sequence	!		Finish		Out of	Calibration					
		Twist in Tul			Fit/Function		Out of	Sequence					

Work Orde Thursday, April				*116	579*					37774	Page 3
Item ID: Revision ID: Item Name: Start Date:	D3609-1 Doubler 4/21/14	Start Qty: 6.00	*6*	Accept	*N900		100)* s	Setup St	-	NS1* NS2*
Required Date: Reference:	4/22/14	Req'd Qty: 6.00	*6*		Customer:						
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):		ate:		R		ор	NR1* NR2*
Sequence ID/ Work Center II 123 *1 22* QC Quality Control	D	Operation Description QC5- Inspect part comple	eteness to step on W/O	Set Up/ Run Hours DAS 0.00 27 959 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Numl	
130 *120* Packaging Packaging		Identify as per dwg & Sto	ock Location	KST 187 0.00				18x			4-4-)- 0 2
140 *140* OC		QC21- Final Inspection -	Work Order Release	0.00				мС	. 5	14-0	4-23

0.00

Memo

Quality Control

MLJ 1404-23 MLJ 1404-23

DQA:			Date:			,							\	TRAGG
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UP		ork Order up	date only		AEROSPACE
Work Orde	٠					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	•	
Part N	-			e		Rework Scrap]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	•					Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite	1	e/Packaging Supplier		Other
Root					Desc	ription of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance		ief Eng	Descri	ption	Date	Verification	۱	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CA	TEGORY	v .				
Landir		Gear Bending Centre No Cracks	ot Concer	ntric		General Bend BOM/Route Broken/Damage/Defect		Folio/F Grain Hardwa	Program		Outside Dim Over/Under Part Incorred	tolerance	Se	ressure/Forced et-up emperature/Cure
		Crimp/Kir Cuffs Crushing	nk/Ripple	/Wave		Burrs Contamination Countersink		instruc	ion Incomplete/Unitions Incomplete/U gned/off center	· —	Part Lost/Mi Part Moved Positioned V			rong Stock Pulled,
		Heat Treat Inspection	n Strip in	Tube		Cut Too Short Drawing Drill Holes		Mislabe Misrea Off-set	eled d		Power Loss/	· .	0	ther
		Turning S Wave/Tw	equence			Finish Fit/Function		Out of	Calibration Sequence					· · · · · · · · · · · · · · · · · · ·

Picklist Print

Thursday, April 17, 2014 3:17:46 PM

Page 1

Work Order ID: 116579

116579

Parent Item:

D3609-1

D3609-1

Parent Item Name: Doubler

Start Date: 4/21/14

Required Date: 4/22/14

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-03-26 JLM

IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

IPP REV:C

AS PER REV C JLM 11-05-04 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	271.3900	1.1769	8	W		
M304S22 304/316 .032 Sheet	PGA								**		mm/	14/00	1/21
- Ú/ -				Location		Loc Q	<u>Oty</u>	Loc Code			/		
*				MAT020		271	.39						
				(m126593	271	.39		_	15.4	_		

M304522GA4P

DQA:			Date:						DA 4 4 4 6 5 / 1 1 D D 4 1	منو میت			"DART
QA Closed:			Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / UPDA		ork Order up	odate only	AEROSPACE
					٠	DISPOSITION			Α		PARTMENT/	· ·	
Work Orde	er: .												, ,
						Rework			—	osstube	_	Water Jet	Engineering
Part N	10.					Scrap			~ <u>~</u>	mall Fab	ŧ	d. Eng. Coor.	Quality
NCD A						Use-as-is		Thern	· —	inishing	Kec/Stor	re/Packaging	Other
NCR N	۱O. ِ					Suspected Unapproved			Large Fab Cor	mposite]	Supplier	
Root					Desc	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup			ł										
Process			ļ							•			
Supplier													,
Training .				!									
Transport Unapproved													
Опаррточеи	<u> </u>	<u> </u>	.1	l	I		FA	ULT CA	TEGORY				
Landi	ng (Gear				General							
	ř	Bending				Bend	Г	Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		1 -	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ci	Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unquali	ified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclea	ar 🔲	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	_
]Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	hatter			Drill Holes		Off-set					
		Turning 9	Sequence			Finish		Out of	Calibration				
!		Wave/Tv	vist in Tub	эe		Fit/Function		Out of	Sequence				

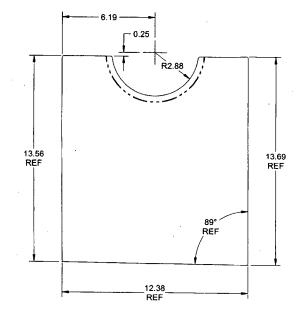
DART AEROSPACE LTD	Work Order:	116579
Description: Doubler	Part Number:	D3609-1
Inspection Dwg: D3609 Rev: D		Page 1 of 1

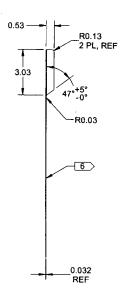
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.032	+/-0.010	0.032			V-54m-05	
12.38	+/-0.030	12.38	V		T. Jkm-07	
13.69	+/-0.030	13.69	V			
13.56	+/-0.030	13.56	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \			
0.65	+/-0.030	0.65	/			
1.00	+/-0.030	1.00				
0.63	+/-0.030	0.63	V			
0.500	+/-0.010	0.581	/			
,						
	!					<u>, , , , , , , , , , , , , , , , , , , </u>
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Measured by: Audited by: 27 Preliminary Approval:		DAS	
	Measured by: max / 67		Preliminary Approval:
Date: 14/04/21 Date: 14(4(2)) Date:	Date: 14/04/21	, a vv	Date:

Revised by	Approved
KJ	
	4 4
er Dwg Rev D KJ	
	er Dwg Rev C KJ





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С

D3609-1 DOUBLER

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14-4-17

NOTES:
1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 1.46 lbs
8) FORM USING DT9763 AND TRIM PER PHANTOM LINE ON SHEET 2

D	REVISE FLAT PATTERN SYMMETRY; R2.75 WAS R2.63 (ZN C6-2)	RF"	11.09.20
С	2.88 WAS 2.98 (ZN C5-1); 3.03 WAS 3.20 (ZN C4-1); 0.53 WAS 0.50 (ZN D4-1); ADD ANGLE TOLERANCE (ZNC3-1); REVISE D3609-1F	RF	11.06.07
В	ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)		11.04.28
Α	NEW ISSUE		07.04.11
REV.	DESCRIPTION	BY	DATE

DESIGN	k	DART AEROSPACE LTD		
DRAWN	ŘF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	-#	DRAWING NO.	REV. D	
MFG. APPR.	E	D3609	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	#	DOUBLER	NTS	
DATE 11.09.20		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPRECHIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON COPING ON COMPANION TO TO ANY OTHER PERSON WITHOUT		

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